



Dart Aerospace Ltd.
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D2858-1

Job Sheet 212565



Part No: D2858-1

Job Qty: 12 pcs

DAS
21
9-89

Part Name: Hinge Bracket



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 8/26/20

Job Tracking No:

Due Date: 9/30/20

Created By: Marie Lajeunesse

Type: Stock

Description: SIOP

Note: DWG REV C IPP C 00.06.22 Removed P/O for powder coat EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Bandsaw - 1	12 pcs		9/29/20	0.00	0.06	Bandsaw - 1		20/09/13
110	HAAS 4 Axis - B4B	12 pcs		9/29/20	1.00	3.35	HAAS - 1 - B4B		
							HAAS - 2 - B4B		
							HAAS - 3 - B4B		12 20-9-15
							HAAS - 4 - B4B		
130	QC 8	12 pcs		9/29/20	0.00	0.00	QC 8 - 12		
							QC 8 - 14		
							QC 8 - 17		
							QC 8 - 20		20-09-15
							QC 8 - 25		
							QC 8 - 3		
							QC 8 - 32		
							QC 8 - 33		
							QC 8 - 35		
							QC 8 - 39		
							QC 8 - 4		
							QC 8 - 44		
							QC 8 - 45		
							QC 8 - 49		
							QC 8 - 58		
							QC 8 - 8		
							QC 8 - 9		
							QC 8 - 68		
							QC 8 - 67		
							QC 8 - 1 (A)		
							QC 8 - 47		
							QC 8 - 40		
							QC 8 - 52		
							QC 8 - 23		
							QC 8 - 57		



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Container No: S300235



Part: D2858-1

Job No: 212565

Serial No/Batch: S300235

Revision: C

Inspector:

Exp Date:

Instructions: Various STC's

Date: 09/15/20

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140 Handfinish - 1-1 Chemical-B4B	12 pcs	9/29/20	0.00 0.13	QC 8 - 76	
				QC 8 - 61	
				QC 8 - 66	
				QC 8 - 73	
				QC 8 - 82	
				Handfinish - 1 - 1 - B4B	
				Handfinish - 1 - 2 - B4B	
				Handfinish - 1 - 3 - B4B	
				Handfinish - 1 - 4 - B4B	
				Handfinish - 1 - 5 - B4B	
				Handfinish - 1 - 6 - B4B	
				Handfinish - 1 - 7 - B4B	
				Handfinish - 1 - 8 - B4B	
				Handfinish - 1 - 9 - B4B	
				Handfinish - 1 - 10 - B4B	
				Handfinish - 1 - 11 - B4B	
				Handfinish - 1 - 12 - B4B	
				Handfinish - 1 - 13 - B4B	
				Handfinish - 1 - 14 - B4B	
				Handfinish - 1 - 15 - B4B	
				Handfinish - 1 - 16 - B4B	
				Handfinish - 1 - 17 - B4B	
				Handfinish - 1 - 18 - B4B	
				Handfinish - 1 - 19 - B4B	
				Handfinish - 1 - 20 - B4B	
				Handfinish - 1 - 21 - B4B	
				Handfinish - 1 - 22 - B4B	
150 Powdercoat - 1 White GI(A)-B4B	12 pcs	9/30/20	0.00 0.16	Powdercoat - 1 - B4B	
				Powdercoat - 2 - B4B	
				Powdercoat - 3 - B4B	
				Powdercoat - 4 - B4B	
				Powdercoat - 5 - B4B	
				Powdercoat - 6 - B4B	
				Powdercoat - 7 - B4B	
				Powdercoat - 8 - B4B	
				Powdercoat - 9 - B4B	
				Powdercoat - 10 - B4B	
160 QC 3	12 pcs	9/30/20	0.00 0.00	QC 3 - 10	
				QC 3 - 13	
				QC 3 - 15	
				QC 3 - 17	

W 2020/09/16

20-19-16 8:30

			QC 3 - 18	
			QC 3 - 2	
			QC 3 - 28	
			QC 3 - 3	
			QC 3 - 30	
			QC 3 - 34	
			QC 3 - 36	
			QC 3 - 41	
			QC 3 - 51	
			QC 3 - 58	
			QC 3 - 59	
			QC 3 - 68	
			QC 3 - 9	
			QC 3 - 40	
			QC 3 - 19	
			QC 3 - 43	
			QC 3 - 24	
			QC 3 - 61	
			QC 3 - 81	
			QC 3 - 82	
			QC 3 - 87	
			QC 3 - 47	
170 Packaging 3-1 - Stock - B4B	12 pos	9/30/20	0.00 0.00	Packaging 3 - 1 - B4B
				Packaging 3 - 2 - B4B
				Packaging 3 - 3 - B4B
				Packaging 3 - 4 - B4B
				Packaging 3 - 5 - B4B
				Packaging 3 - 6 - B4B
				Packaging 3 - 7 - B4B
				Packaging 3 - 8 - B4B
				Packaging 3 - 9 - B4B
				Packaging 3 - 10 - B4B
				Packaging 3 - 11 - B4B
				Packaging 3 - 12 - B4B
				Packaging 3 - 13 - B4B
				Packaging 3 - 14 - B4B
				Packaging 3 - 15 - B4B
				Packaging 3 - 16 - B4B
				Packaging 3 - 17 - B4B
				Packaging 3 - 18 - B4B
				Packaging 3 - 19 - B4B
				Packaging 3 - 20 - B4B
				Packaging 3 - 21 - B4B
				Packaging 3 - 22 - B4B
				Packaging 3 - 23 - B4B
				Packaging 3 - 24 - B4B
				Packaging 3 - 25 - B4B
				Packaging 3 - 26 - B4B
				Packaging 3 - 27 - B4B
				Packaging 3 - 28 - B4B
				Packaging 3 - 29 - B4B
				Packaging 3 - 30 - B4B
				Packaging 3 - 31 - B4B
				Packaging 3 - 32 - B4B
				Packaging 3 - 33 - B4B
				Packaging 3 - 34 - B4B
				Packaging 3 - 35 - B4B
				Packaging 3 - 36 - B4B
				Packaging 3 - 37 - B4B

DAS
82
9-89

SEP 16 2020

DAS
28
1-89

SEP 17 2020

180 QC 21 - SA

12
pcs

9/30/20

0.00 0.00

QC 21 - SA - 21

21
9-69

SEP 17 2020

QC 21 - SA - 70

QC 21 - SA - 9

QC 21 - SA - 77

Part Op 100 - (Bandsaw) Cut blanks 5.850 " Note: 1 Blank Makes 3 Parts

Descriptions: 110 - (HAAS CNC Vertical Machine) 1-Machine per folio FA941 FOLIO REV: AA DWG REV: C 2-Debur
any rough edges

130 - (QC8- Inspect parts - second check)

140 - (Chemical Conversion Coat per QSI005 4.1)

150 - (White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum) START TIME: 11:10 OVEN TEMPERATURE: M25/H69320° FINISH TIME: 11:40

160 - (QC3- Inspect Part Finish)

170 - (Identify as per dwg & Stock Location: _____)

180 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6B1.250X1.500	6061-T6 Bar 1.250 X 1.500	1.9560 ft (.163 ea)	100-Bandsaw - 1	<u>3195466 X 6</u>

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Bandsaw - 1	M6061T6B1.250X1.500	2	14	0

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Hinge Bracket	0.171inches + 0.005 - 0.001	0.176 0.170	.172	VERW JL-2
2	Hinge Bracket	0.400inches + 0.006 - 0.001	0.406 0.399	.402	"
3	Hinge Bracket	0.125inches ± 0.010	0.135 0.115	R.125	"
4	Hinge Bracket	0.328inches ± 0.010	0.338 0.318	.328	"
5	Hinge Bracket	0.820inches ± 0.005	0.825 0.815	.820	"
6	Hinge Bracket	1.476inches ± 0.010	1.486 1.466	1.476	"
7	Hinge Bracket	0.342inches ± 0.010	0.352 0.332	.342	"
8	Hinge Bracket	0.875inches ± 0.005	0.880 0.870	.875	"
9	Hinge Bracket	1.560inches ± 0.030	1.590 1.530	1.562	"
10	Hinge Bracket	0.147inches ± 0.010	0.157 0.137	.150	"
11	Hinge Bracket	0.717inches ± 0.010	0.727 0.707	.723	H-G
12	Hinge Bracket	0.697inches ± 0.010	0.707 0.687	.697	VERW JL-2
13	Hinge Bracket	0.229inches ± 0.010	0.239 0.219	.229	"
14	Hinge Bracket	0.125inches ± 0.010	0.135 0.115	.125	R-G
15	Hinge Bracket	0.063inches ± 0.010	0.073 0.053	.063	R-G
16	Hinge Bracket	0.063inches ± 0.010	0.073 0.053	.064	"
17	Hinge Bracket	0.126inches ± 0.010	0.136 0.116	.127	VERW JL-2
18	Hinge Bracket	0.630inches ± 0.010	0.640 0.620	.632	"
19	Hinge Bracket	0.354inches ± 0.010	0.364 0.344	.354	"
20	Hinge Bracket	0.965inches ± 0.010	0.975 0.955	.968	"
21	Hinge Bracket	0.166inches + 0.005 - 0.000	0.171 0.166	.168	VERW JL-2
22	Hinge Bracket	0.125inches ± 0.010	0.135 0.115	R.13	"
23	Hinge Bracket	32.700Degrees ± 0.500	33.200 32.200	32.7°	"

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Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					